

Work Order ID 121624

Monday, June 30, 2014 11:03:13 AM

121624

Page 1

Item ID: D4808-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rod End Bearing Assembly
 Start Date: 8/15/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 8/15/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: CZ Date: 14/06/30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4808	REV <u>B</u>

100 0.00

100

Outsource5

Outsource process - Machining

DOOSAN LATHE

Memo

ISSUE P.O: 24906
 POSSIBLE SUPPLIER: ATG

C OF C IS REQUIRED

CZ 14/07/08 10

110 0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

RCV S. INSPECT.

Memo

0.00

CZ 14/12/16

140 0.00

140

QC

Quality Control

QC3- Inspect parts - second check

Memo

100% CHECK, CHECK ALL DIMENSIONS AND THREAD FIT

0.00

CZ 14/07/08

(10)

DAS
 38
 9-89

DEC 16 2014

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Page 2

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Start Date: 8/15/2014 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/15/2014 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	PURCHASING								
Outsource2	Memo	0.00							
Outsource process - NDT	Issue P/O: <u>B 24906</u>								
	LPI Per ASTM 1417 LEVEL 2								
	Certificate of conformaty is required								
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
161		0.00							
161									
Small Fab	Memo	0.00							
Small Fab	SWAGE AS PER DWG								

Q2 14/07/08

done @ ATG

10X 8014-12-16

10X DAS 28 9-89 FEB 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							38 9-89
170						(10)			FEB 20 2015
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>SH130</u>	0.00							
180						10			DAS 06 3-89
Packaging	Memo	0.00							FEB 21 2015
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									15/2/23 JJ
QC	Memo	0.00							
Quality Control									

MS-2-23

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

Monday, June 30, 2014 11:03:12 AM

Page 1

Work Order ID: 121624

121624

Parent Item: D4808-041

D4808-041

Parent Item Name: Rod End Bearing Assembly

Start Date: 8/15/2014

Required Date: 8/15/2014

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 14-01-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4596-1		Manufactured	No				Each	10.0000		10			
---------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--

D4596-1

Spherical Bearing

N/A obsolete

CLIS/02/19,

Location

Loc Qty

Loc Code

prelim

10

116499

10

D4808-1P

Purchased

No

Each

0.0000

10

D4808-1P

Rod End

M174PH-H900R1.000

Purchased

No

f

127.3000

3

M174PH-H900R1 000

17-4SS H900 ROUND BAR 1.00

Location

Loc Qty

Loc Code

MAT031

127.3

m126952

22.3

m127334

57

m128314

48

3 2+

** D4808-3 CLIS/02/19*
ST128
30 PCS stock
B127960

X10

127960

DAS
28
9-89

FEB 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

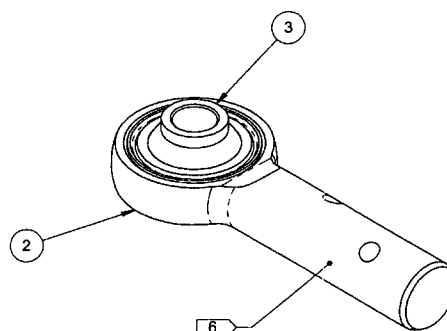
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4808-041	ROD END BEARING ASSEMBLY
2	1	D4808-1	ROD END
3	1	D4808-3	SPHERICAL BEARING



D4808-041 ROD END BEARING ASSEMBLY

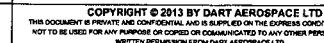
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) SWAGE D4808-3 BEARING INTO D4808-1 ROD END PER DART QSI 002 4.3 USING HIGH PERFORMANCE VEHICLE ENGINEERING SWAGING TOOL SWAG-4HM

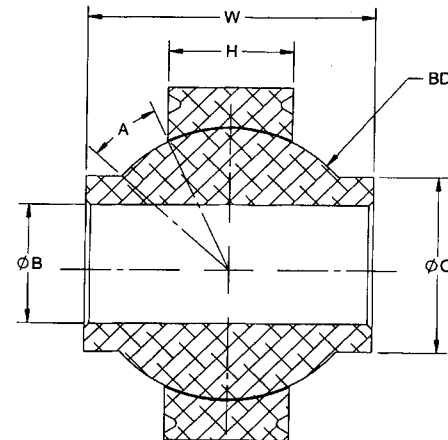
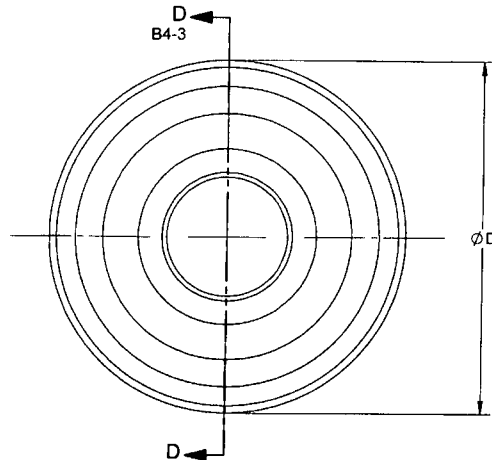
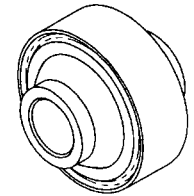
RELEASED
2014-12-17

B	D4808-3 WAS D4596-1 (ZN D4-1). REVISED NOTE 8 (ZN A8-1). ADDED D4808-3 (ZN A5-3).		AK	14.12.01
A	NEW ISSUE		RF	13.08.16
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AK			
CHECKED	RF	DRAWING NO.		REV. E
MFG. APPR.	JLM	D4808		SHEET 1 OF 3
APPROVED	HS	TITLE		SCALE
DE APPR.	DS	ROD END BEARING		NTS
DATE	14.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

APPROVED



SPECIFICATION CONTROL DRAWING



SECTION D-D

D6-3

DART PART NUMBER	DESCRIPTION	MANUFACTURER	MANUFACTURER PART NUMBER	SUPPLIER	"ØB"	"ØD"	"W"	"H"	"ØO"	"BD"	"A"	WEIGHT
D4808-3	SPHERICAL BEARING	AURORA BEARING COMPANY	HAB-4TG OR HAB-4TG-500	ROD ENDS MECHANICAL	0.250	0.740	0.593	0.255	0.390	0.593	24°	0.04 LBS

D4808-3 SPHERICAL BEARING

RELEASED
2014-12-17

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4808	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ROD END BEARING	NTS
DATE	14.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24906

Purchase Order Date 7/8/2014
PO Print Date 8/20/2014

Page Number 7 of 8

Order From :

VC-ATG001

A.F.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total:

\$3,900.00

D4808-1P

Rod End

12/19/2014 FN

10.00

Yes

Each

\$138.50

\$1,385.00

AS PER DWG D4808-1 REV. A

Q121624

MAT: 174PH-H900R 1" M127334

12/19/2014

8814-12-16.

Line Total:

\$1,385.00

D4869-1P

End Fitting, Eye

12/19/2014 FN

24.00

Yes

Each

\$125.00

\$3,000.00

AS PER DWG D4869-1 REV. A

Q121386

MAT: 174PH-H900R 1" M127334

12/19/2014

Line Total:

\$3,000.00

Note:

8/20/2014



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 909316

Date: 16-Dec-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
24 ea	Part: D4870-1P END FITTING, SMALL Job: 16636	PO: PO24906	Rev: A Line: 1
16 ea	Part: D4805-5P END FITTING Job: 16649	PO: PO24906	Rev: A Line: 14
18 ea	Part: D4869-3P END FITTING, EYE Job: 16650	PO: PO24906	Rev: A Line: 15
30 ea	Part: D4805-3P END FITTING Job: 16652	PO: PO24906	Rev: A Line: 17
✓ 10 ea	Part: D4808-1P ROD END Job: 16653	PO: PO24906	Rev: A Line: 18
24 ea	Part: D4869-1P END FITTING, EYE Job: 16654	PO: PO24906	Rev: A Line: 19
24 ea	Part: D4870-3P END FITTING, LARGE Job: 16637	PO: PO24906	Rev: A Line: 2
29 ea	Part: D4871-1P END FITTING Job: 16638	PO: PO24906	Rev: A Line: 3
30	Part: D4871-3P		Rev: A

SP14-12-16



F.A.I.

First Article Inspection Report

#

538

Requesting Company: Dart Aerospace

PO#: PO24906

Line: 18

Qty: 10

Part Number: D4808-1P

Rev: A

Part Description: Rod End

FAI Supplied by: A.T.G. Industries Inc.

FAI Prepared by: Emily Louis-Seize

Date: July 14, 2014

Qty Inspected: 10

FAI Inspected by: Mike Csontos

Date: December 14, 2014

Material and/or Special Processes

Type	Description	Specification Number/Code	Certificate of Conformance Number:
Material	17-4SS H900		Supplied by Customer
Special Process	Liquid Penetrant	QSI 038 6.1.1 (ASTM E1417 Level 2)	PO#: 20140501

Inspection Information and Results

Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
1	D6	2.32	2.319	inch	Pass	Vernier Caliper	2
2	D5	.030	.029	inch	Pass	Comparator	2
3	C5	.017	.018	inch	Pass	Comparator	2
4	C5	Ø.420+.000/-.001	Ø.4196	inch	Pass	Micrometer	1
5	C5	.38	.38	inch	Pass	Micrometer	4
6	C6	.500	.500	inch	Pass	Micrometer	4
7	C6	.980±.005	.981	inch	Pass	Height Gauge	4
8	C4	Ø.125	Ø.125	inch	Pass	Gauge Pin	4
9	C3	30°	30°	degree	Pass	Comparator	4
10	C2	30°	30°	degree	Pass	Comparator	4
11	C1	Ø.125	Ø.125	inch	Pass	Gauge Pin	4

Inspection Information and Results

Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
12	B7	$\varnothing.7400+.0003/-0.0002$	$\varnothing.7399$	inch	Pass	Gauge Pin	3
13	B6	1.27	1.282	inch	Pass	Comparator	3
14	B6	R.25 TYP	R.25	inch	Pass	Radius Gauge	3
15	B7	.020 x 45° Chamfer	.023 x 45°	inch/degree	Pass	Comparator	3
16	B8	.255	.253	inch	Pass	Vernier Caliper	3
17	B2	$\varnothing.910$	$\varnothing.909$	inch	Pass	Vernier Caliper	1

First Article Inspection Report Approved and
Completed in Full by:

M. Canty

Date:

15-Dec-14



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23016	Customer: ATG Industries Inc	Dept: NDT YUL	Reference: 20140501
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 9

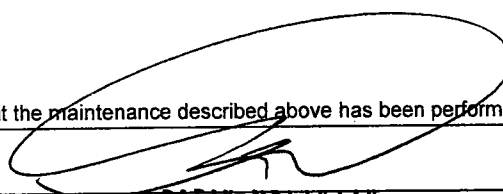
Work Required:

CARRY OUT NDT ON 11 ROD END P/N D4808-1P AS PER PO: 20140501

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN.(ZL-37 , B#10A070), DEV.(SKD-S2,B#13D14k) , EMU.(ZR-10B,B#10A074).						DEC 10 2014	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: DEC 10 2014
Name: RAFIK MELIKIAN		